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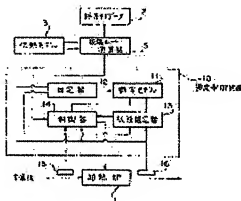
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(54) METHOD FOR CONTROLLING SHEET TEMPERATURE IN METALLIC SHEET HEATING FURNACE

(57)Abstract:

PURPOSE: To precisely heat a metallic sheet in a heating furnace to a desired temp. by obtaining a sheet temp. predicted value to minimize the difference from a sheet temp. command from the time sequential data related to the metallic sheet to be annealed and the heat-transfer model in the heating furnace at the time of annealing a metallic sheet in the continuous annealing furnace.

CONSTITUTION: When a long-sized metallic sheet is continuously annealed in the heating furnace 1 such as a continuous annealing furnace, a sheet temp. predicted value to minimize the difference from a sheet temp. command is obtained by a sheet temp. root computing element 5 based on the time sequential data 2 storing the size, specific heat, and sheet temp. command of a metallic sheet to be heated and the physical transfer model 3 expressing the relative heat-transfer shape among the radiant tube, hearth roll, steel sheet, etc., in the heating furnace 1. The temp. of the heating furnace 1 is appropriately controlled by an adaptive controller 10 with the sheet temp. command as the set value to control the heating (annealing) of the metallic sheet with high efficiency in the heating furnace 1, hence the generation of defective steel sheets is reduced, and the yield of the annealed steel sheets is improved.



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